

Work Order ID 110446

December-19-13 3:25:55 PM

*Push*

\*110446\*

*20 A S 14/01/22*

~~PRELIMINARY ISSUE~~  
~~PRELIMINARY ISSUE~~

Page 1

Item ID: D5023-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: PRELIM Stop \*NS2\*  
 Item Name: Cover Plate  
 Start Date: 12/19/13 Start Qty: 3.00 \*3\* Cust Item ID:  
 Required Date: 1/02/14 Req'd Qty: 3.00 \*3\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12-15 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D5023	<u>A11</u> <i>Rev A</i>								

DAS  
10  
989

110 0.00  
 \*110\* 3 EL 13-12-23  
 Waterjet

FLOW CNC Waterjet Memo  
 1-Cut D5023-3 as per Dwg  
 Dwg Rev: A11  
 Prog Rev: A11  
 2-Deburr if necessary

120 0.00  
 \*120\* 3 EL 13-12-23  
 QC

Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB



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Page 2

Item ID: D5023-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID: PRELIM

Item Name: Cover Plate

Stop \*NS2\*

Start Date: 12/19/13 Start Qty: 3.00

\*3\*

Cust Item ID:

Required Date: 1/02/14 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

DAS

27

9-89

13/12/23

3

Inspection  
Dwg All

3

13-12-24

3

13-12-24

DAS

34

9-89

Work Order ID 110446

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Page 3

Item ID: D5023-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID: PRELIM

Item Name: Cover Plate

Stop \*NS2\*

Start Date: 12/19/13 Start Qty: 3.00

\*3\*

Cust Item ID:

Required Date: 1/02/14 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per OSI005 4.3	0.00							
<b>*160*</b>	<i>M126878.</i>					<i>3</i>	<i>0</i>	<i>13-12-24.</i>	<b>DAS</b>
Powdercoat	Memo	0.00							<b>34</b>
Powder Coating	START TIME: <i>8:00</i>								<b>9-89</b>
	OVEN TEMPERATURE: <i>320</i>								
	FINISH TIME: <i>8:00.</i>								
170	QC3- Inspect Part Finish	0.00							<b>DAS</b>
<b>*170*</b>									<b>9</b>
QC	Memo	0.00						<i>② 13-12-30</i>	<b>9-89</b>
Quality Control									
180	Identify as per dwg & Stock Location: <i>prelim</i>	0.00							
<b>*180*</b>									
Packaging	Memo	0.00							
Packaging									

*mk 13-12-30**release Dwg  
as per Rev A*

Work Order ID 110446

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\*110446\*

Page 4

Item ID: D5023-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: PRELIM Stop \*NS2\*  
 Item Name: Cover Plate  
 Start Date: 12/19/13 Start Qty: 3.00 \*3\* Cust Item ID:  
 Required Date: 1/02/14 Req'd Qty: 3.00 \*3\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21 - Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

0.00

Quality Control

*RM 13/12/31*

*11-01-23*

*WLF  
13-12-30*

*RD4455A*

POSITIVE RECALL  
 EFFECTIVE 13.12.19 AUTH u  
 RELEASED 8 DATE 14/1/12  
*to Rev A Drawing*

# Picklist Print

December-19-13 3:25:59 PM

Page 1/1

Work Order ID: 110446

**\*110446\***

Parent Item: D5023-3

**\*D5023-3\***

Parent Item Name: Cover Plate

Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 13.12.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

sf

348.7600

2

**\*M6061T6S 080\***

**\*\***

*BZ 13-12-23*

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

348.76

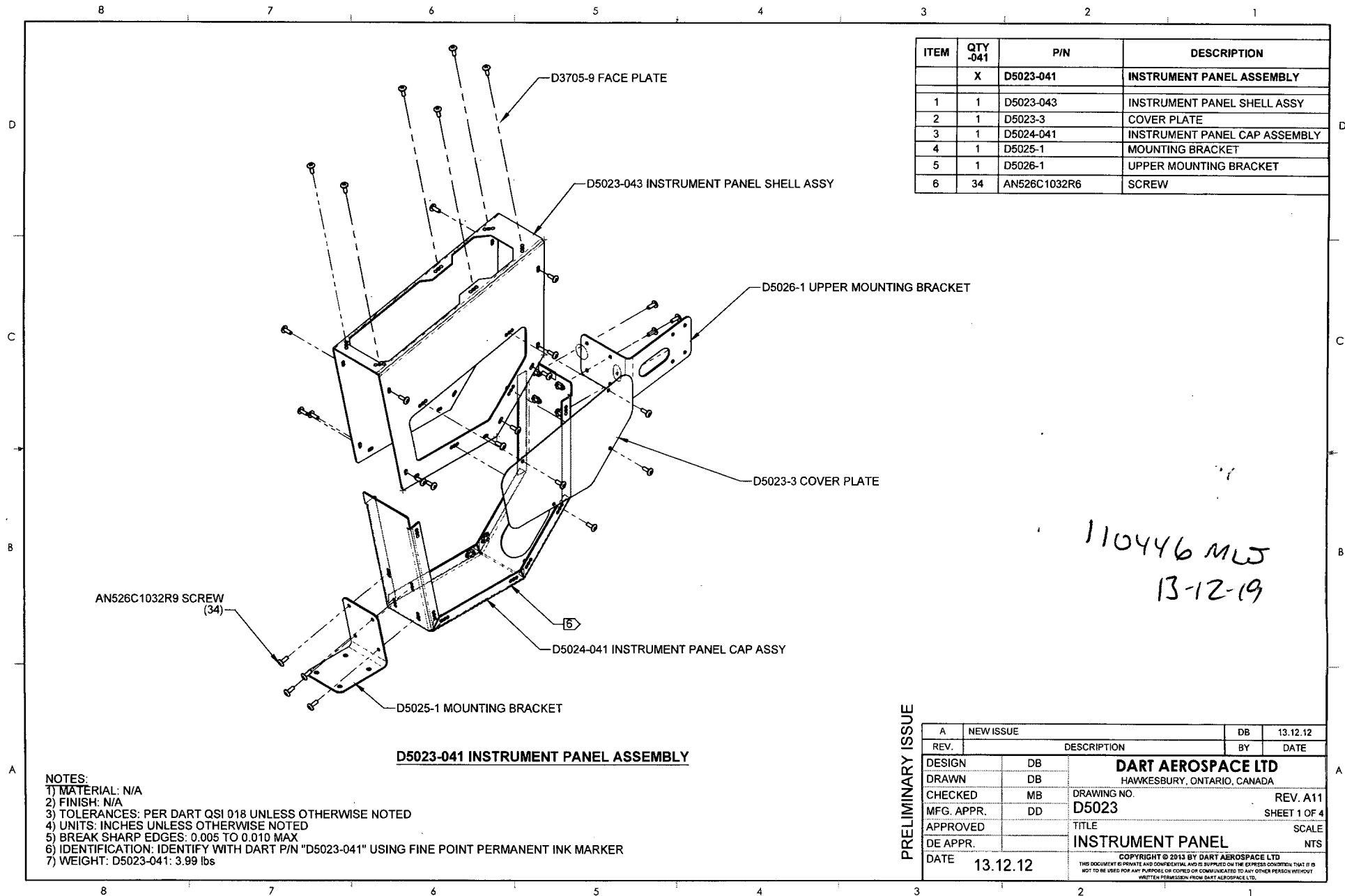
m126309

327

m126350

21.76

2

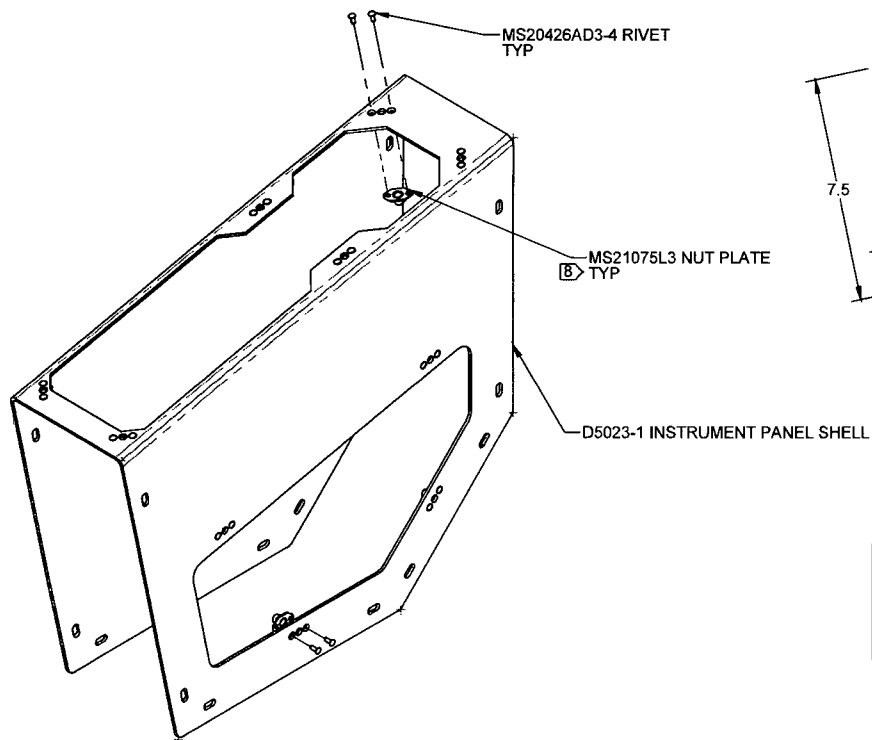


ITEM	QTY -041	P/N	DESCRIPTION
	X	D5023-041	INSTRUMENT PANEL ASSEMBLY
1	1	D5023-043	INSTRUMENT PANEL SHELL ASSY
2	1	D5023-3	COVER PLATE
3	1	D5024-041	INSTRUMENT PANEL CAP ASSEMBLY
4	1	D5025-1	MOUNTING BRACKET
5	1	D5026-1	UPPER MOUNTING BRACKET
6	34	AN526C1032R6	SCREW

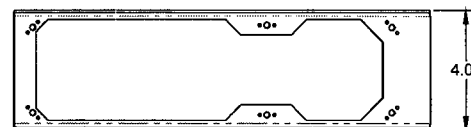
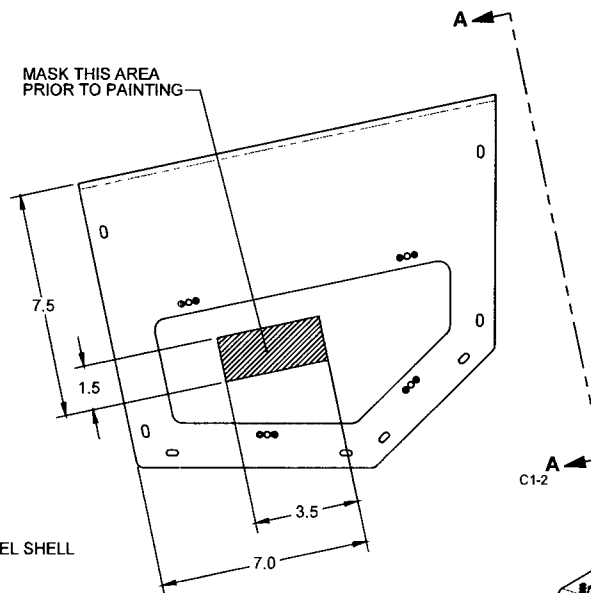
PRELIMINARY ISSUE

A	NEW ISSUE	DB	13.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. A11
MFG. APPR.	DD	D5023	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL	NTS
DATE	13.12.12	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

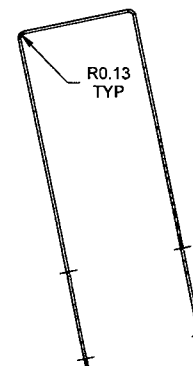
ITEM	QTY -043	P/N	DESCRIPTION
	X	D5023-043	INSTRUMENT PANEL SHELL ASSEMBLY
1	1	D5023-1	INSTRUMENT PANEL SHELL
2	10	MS21075L3	NUT PLATE, SELF-LOCKING, FLOATING
3	20	MS20426AD3-4	RIVET, CSK



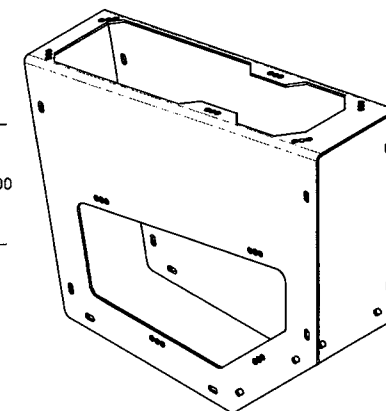
**D5023-043 INSTRUMENT PANEL SHELL ASSY**



**D5023-1 INSTRUMENT PANEL SHELL**  
(MAKE FROM D5023-1F)



**VIEW A-A** C2-2



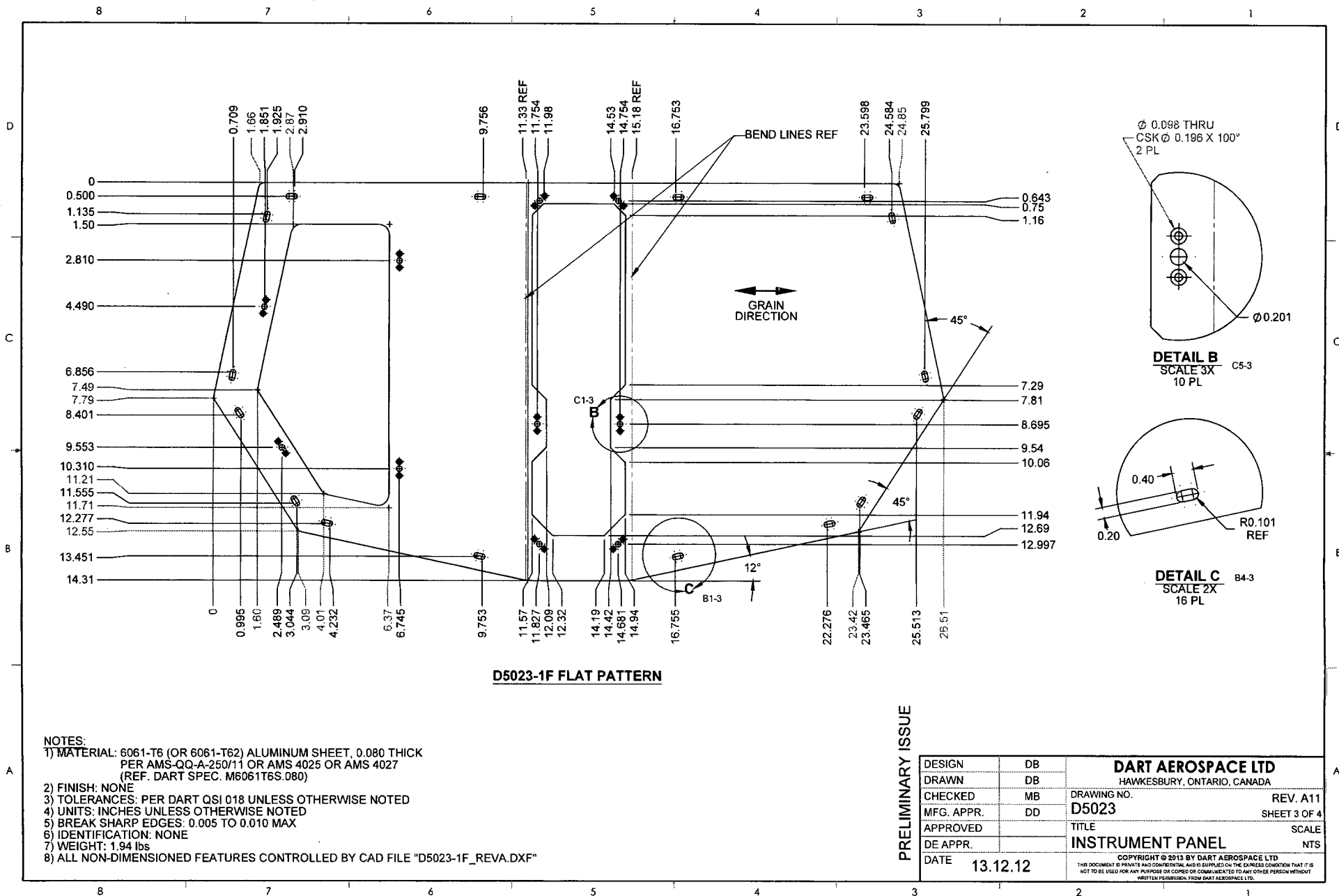
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: D5023-1: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
D5023-043: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D5023-043: 1.97 lbs
- 8) MASK NUTPLATE THREADS PRIOR TO PAINTING

PRELIMINARY ISSUE

DESIGN	DB	<b>DART AEROSPACE LTD</b>	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. A11
MFG. APPR.	DD	<b>D5023</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>INSTRUMENT PANEL</b>	NTS
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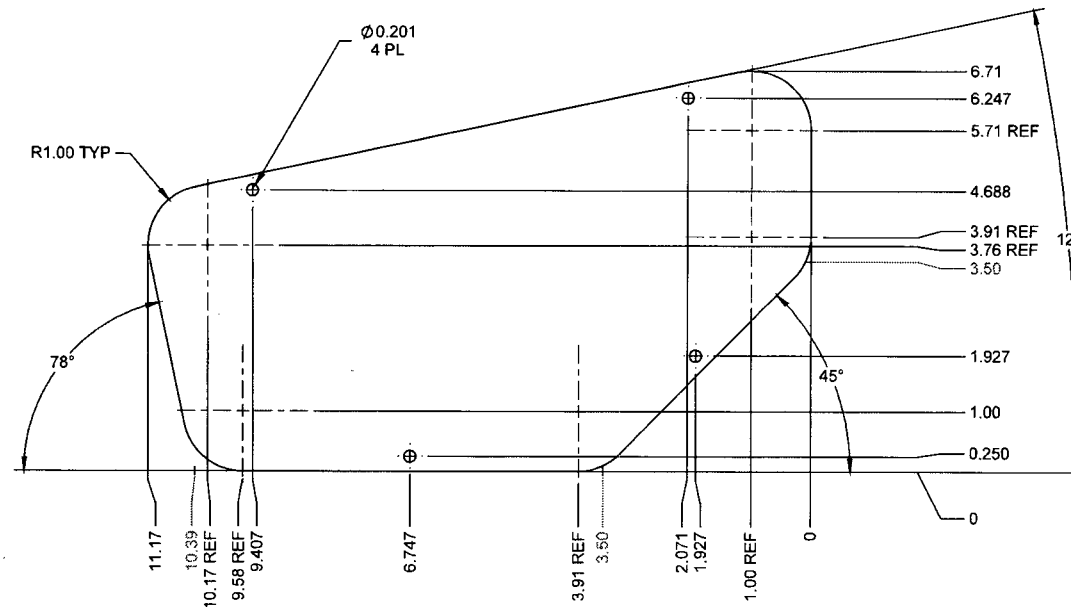
**D5023-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.94 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5023-1F\_REVA.DXF"

**PRELIMINARY ISSUE**

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DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. A11
MFG. APPR.	DD	D5023	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>INSTRUMENT PANEL</b>	NTS
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**D5023-3 COVER PLATE**

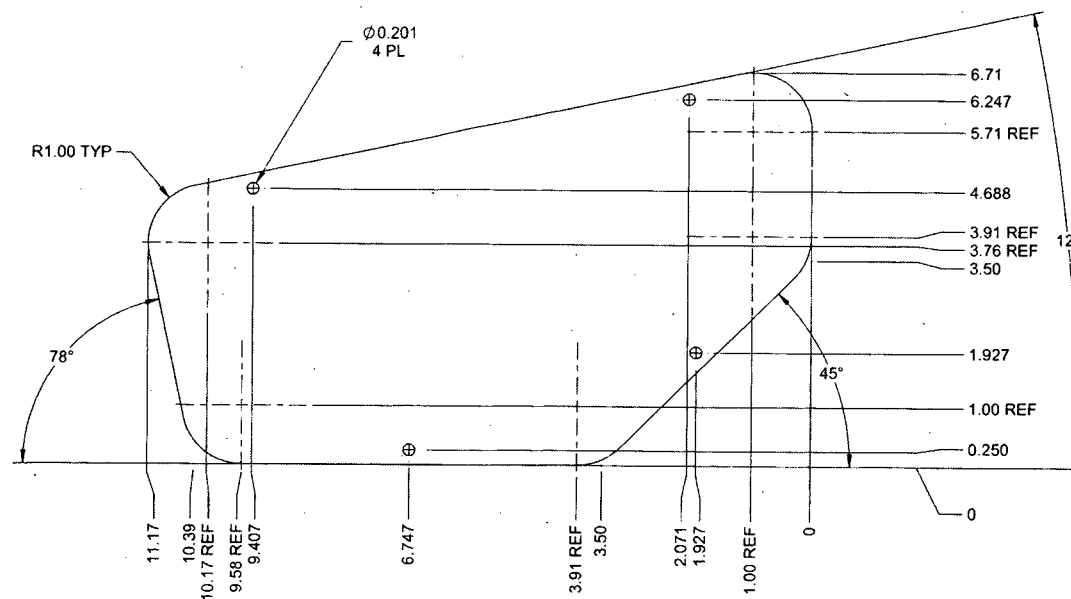
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5023-3\_REVA.DXF".

PRELIMINARY ISSUE

DESIGN	DB	<b>DART AEROSPACE LTD</b>	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. A11
MFG. APPR.	DD	D5023	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL	NTS
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**D5023-3 COVER PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5023-3\_REVA.DXF".

APPROVED	DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	MB	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5023	SHEET 4 OF 4
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	<b>INSTRUMENT PANEL</b>	NTS
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